



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5425-043

Job Sheet 198593



Part No: D5425-043

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/30/19

Description:

Note: DWG D5425 REV.B IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER DWG
REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs		8/30/19	0.00	0.50	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4	TF	
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	HAAS 4 Axis - B4B	1 pcs		8/30/19	1.00	22.77	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 2	1 pcs		8/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



Container No: S209440



Part: D5425-043

Job No: 198593

Serial No/Batch: S209440

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/27/19

Plex 7/31/19 8:02 AM Dart.lajeunesse.marie

				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	mm. 2011/10/27
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
140 QC 8	1	8/30/19	0.00 0.00	QC 8 - 12	
	pcs			QC 8 - 14	mm. 19/10/27
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Handfinish - 1-1 Chemical-B4B	1	8/30/19	0.00 0.25	Handfinish - 1 - 1 - B4B	
	pcs			Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	OCT 30 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 -	

7/31/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	1 pcs	8/30/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	DAS
				QC 7 - 67	76
				QC 7 - 40	9-89 2017-11-14
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
170 Skidtubes - Bend - 2 - B4B	1 pcs	8/30/19	0.50 1.00	Skidtubes - Bend - B4B	P 17/11/04
180 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BF
				QC 5 - 19	
				QC 5 - 22	

Plex 7/31/19 8:02 AM Dart.lajeunesse.marie

						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
190 Skidtubes - 2 - B4B	1 pcs	8/30/19	0.00	1.25		Skidtubes - 1 - B4B	
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	
						Skidtubes - 4 - B4B	
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
200 QC 5	1 pcs	8/30/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
210 Handfinish - 6-1- Touch Up - B4B	1 pcs	8/30/19	0.00	0.25		Handfinish - 6 - 1 - B4B	
						Handfinish - 6 - 2 - B4B	
						Handfinish - 6 - 3 - B4B	
						Handfinish - 6 - 4 - B4B	
						Handfinish - 6 - 5 - B4B	
						Handfinish - 6 - 6 - B4B	
						Handfinish - 6 - 7 - B4B	
						Handfinish - 6 - 8 - B4B	
						Handfinish - 6 - 9 - B4B	
						Handfinish - 6 - 10 - B4B	
						Handfinish - 6 - 11 - B4B	

19-11-06

DAS
NOV 06 2019 68
9-89

3E319/11-06

						Handfinish - 6 - 12 - B4B	
						Handfinish - 6 - 13 - B4B	
						Handfinish - 6 - 14 - B4B	
						Handfinish - 6 - 15 - B4B	
						Handfinish - 6 - 16 - B4B	
						Handfinish - 6 - 17 - B4B	
						Handfinish - 6 - 18 - B4B	
						Handfinish - 6 - 19 - B4B	
						Handfinish - 6 - 20 - B4B	
						Handfinish - 6 - 21 - B4B	
						Handfinish - 6 - 22 - B4B	
220 QC 7	1 pcs	8/30/19	0.00	0.00		QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	TW
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
230 Skidtubes - 3 - B4B	1 pcs	8/30/19	0.00	2.00		Skidtubes - 1 - B4B	
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	
						Skidtubes - 4 - B4B	
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	TW
						Skidtubes - 7 - B4B	
240 QC 5	1 pcs	8/30/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	

https://www.plexonline.com/bb4ea749-e7e5-4736-9803-5dba2791d888/Plexus_Control/Report_Viewer_2.asp?URL=./Part/Job_Sheet.asp&Report=T... 6/10

				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
270 Spray Paint - 2 - B4B	1 pcs	8/30/19	0.00 1.00	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
280 QC 14	1 pcs	8/30/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
290 Handfinish - 4-1-Assembly-B4B	1 pcs	8/30/19	0.00 0.25	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 -	

						B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
300 QC 5	1	8/30/19	0.00	0.00	pcs	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
310 Packaging 3-1 - Stock - B4B	1	8/30/19	0.00	0.00	pcs	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	

DAS
NOV 13 2019 68
9-89

ML 14/11/19

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
320 QC 21 - SA	1	8/30/19	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	53

NOV 14 2019

Part Op 110 - 1-Cut tube to finished length as per Dwg. 2-Deburr ends as per Dwg.
 Descriptions: 120 - 1-Machine as per Dwg. and Folio FB536 DWG REV: B FOLIO REV: AA 2-Deburr as per Dwg.
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 150 - 1-Scrub inside of tube with medium scotchbright.
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - 1-Bend Aft end of tube as per Dwg. and Folio . Insert Bending mandrel DT 10328 at 20.0" from aft end. Use buggy A,B,C. to stabilize tube. HEIGHT 2-Bend Forward end of tube as per Dwg. and Folio . Insert Bending mandrel DT 10328 at 12.0" from fwd end. Use buggy A,B,C To stabilize tube. HEIGHT 3-Record dimensions on work order.
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - 1-Drill remaining holes of DETAIL M, N, P. USING DT10340 A,B,C,D 2-Open holes to finished size as per Dwg. 3-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube.
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - Handfinish Touch up alodine
 220 - (QC7-Inspect Chemical Conversion Coat)
 230 - 1-Wet install crossbolt spacers of Section G-G. Swage to 0.437 as per Dwg. PRIMER B 5/68160 Start Time: 12:00 Finish Time: 6:00pm ***CURE TIME 6HRS. BEFORE PROCEEDING TO NEXT STEP*** 2-Swage crossbolt spacers of Section F-F to 0.313 as per Dwg. 3-Trim / Grind flush, deburr. 4-Identify per QSI 044 6.1
 240 - (QC5- Inspect part completeness to step on W/O)
 250 - (Touch up alodine) ***DO NOT SUBMERGE TUBE IN DEOXIDIZER***
 260 - (QC7-Inspect Chemical Conversion Coat)
 270 - (Spray Paint / NDT Room) ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5200299 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: 5213125
 280 - (QC14- Inspect Spray Paint)
 290 - (Assemble as per dwg) 1-Install FWD and AFT cap seal with sikaflex-241 / 291 5200625 Exp: 2-01-07. Start time: 9:00AM Finish time: 9:00PM 2-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon B M133690
 300 - (QC5- Inspect part completeness to step on W/O)
 310 - (Identify as per dwg & Stock Location:)
 320 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6028-195	Crosstube Material, 7075-T73/T73511	1 pcs (1 ea)	110-Skidtubes - 1	S18TS96
D5518-1	Crossbolt Spacer	18 pcs (18 ea)	230-Skidtubes - 3 - B4B	S225903
D5512-1	Crossbolt Spacer	12 pcs (12 ea)	230-Skidtubes - 3 - B4B	S218968
AN3C5A	Bolt	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	S123445
D3672-1	Washer, Phenolic	6 pcs (6 ea)	290-Handfinish - 4-1-Assembly-B4B	F164008
D5483-041	Tow Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	S199399
D5484-041	Aft Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	S200349
NAS1149C0332R	Washer (AN960C10L)	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	S218154

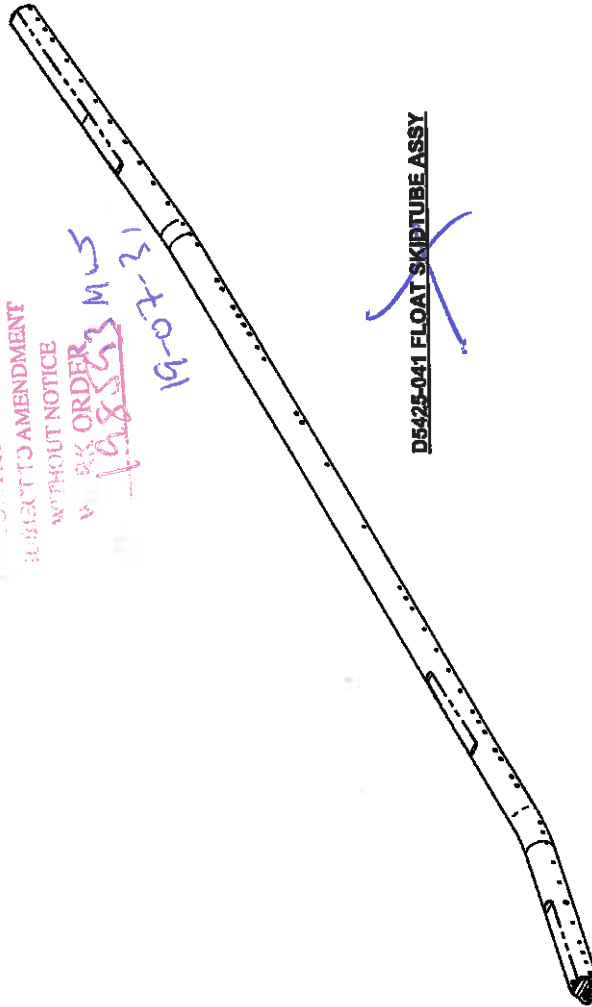
M.U. 012842

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D6028-195	1	5	0
230-Skidtubes - 3 - B4B	D5512-1	12	44	0
	D5518-1	18	126	0
290-Handfinish - 4-1-Assembly-B4B	AN3C5A	6	765	0
	D3672-1	6	1,581	0
	D5483-041	1	20	0
	D5484-041	1	7	0
	NAS1149C0332R	6	3,684	0
Part Specifications				
Specifications could not be found.				

Plex 7/31/19 8:02 AM Dart.lajeunesse.marie

QTY	P/N	DESCRIPTION
1	D5425-041	FLOAT SKIDTUBE ASSY
6	D3872-1	WASHER
1	D5425-1	FLOAT SKIDTUBE
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
37	D5518-1	CROSSBOLT SPACER
6	A1305A	BOLT
6	NA31148C032R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
FOR CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
W/ EX ORDER
198553 M/S
19-07-7-31



D5425-041 FLOAT SKIDTUBE ASSY

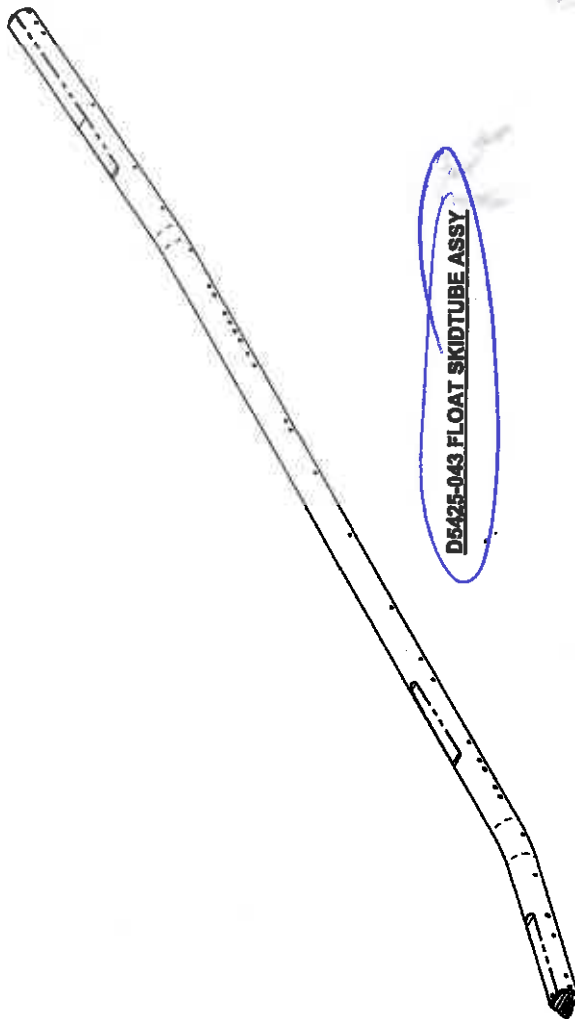
RELEASED
2018 AUG 16
EUGENE, OR

B		CHANGE HOLE SIZE TO IMPROVE OFF-AXIS SWAGING IN SHEET 12 (PART 1) (NCS 14-5741). PICTORIAL UPDATE DUE TO DISCREPANCY IN DIMENSIONS.		NO	18.02.05
A		NEW ISSUE		NO	17.07.19
REV.		DESCRIPTION		BY	DATE
DESIGN		NO		DART AEROSPACE USA, INC.	
DRAWN		NO		EUGENE, OR	
CHECKED		ZF		REV. B	
MFG. APPR.		DD		DRAWING NO. D5425	
APPROVED		NO		SHEET 1 OF 10	
DE APPR.		DS		TITLE 412 FLOAT SKIDTUBE	
DATE		18.02.05		SCALE NTS	

APPROVED

COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.
THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.

QTY -043	P/N	DESCRIPTION
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D6489-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D6512-1	CROSSBOLT SPACER
18	D6518-1	CROSSBOLT SPACER
6	AN305A	BOLT
8	NAS1149C0332R	WASHER

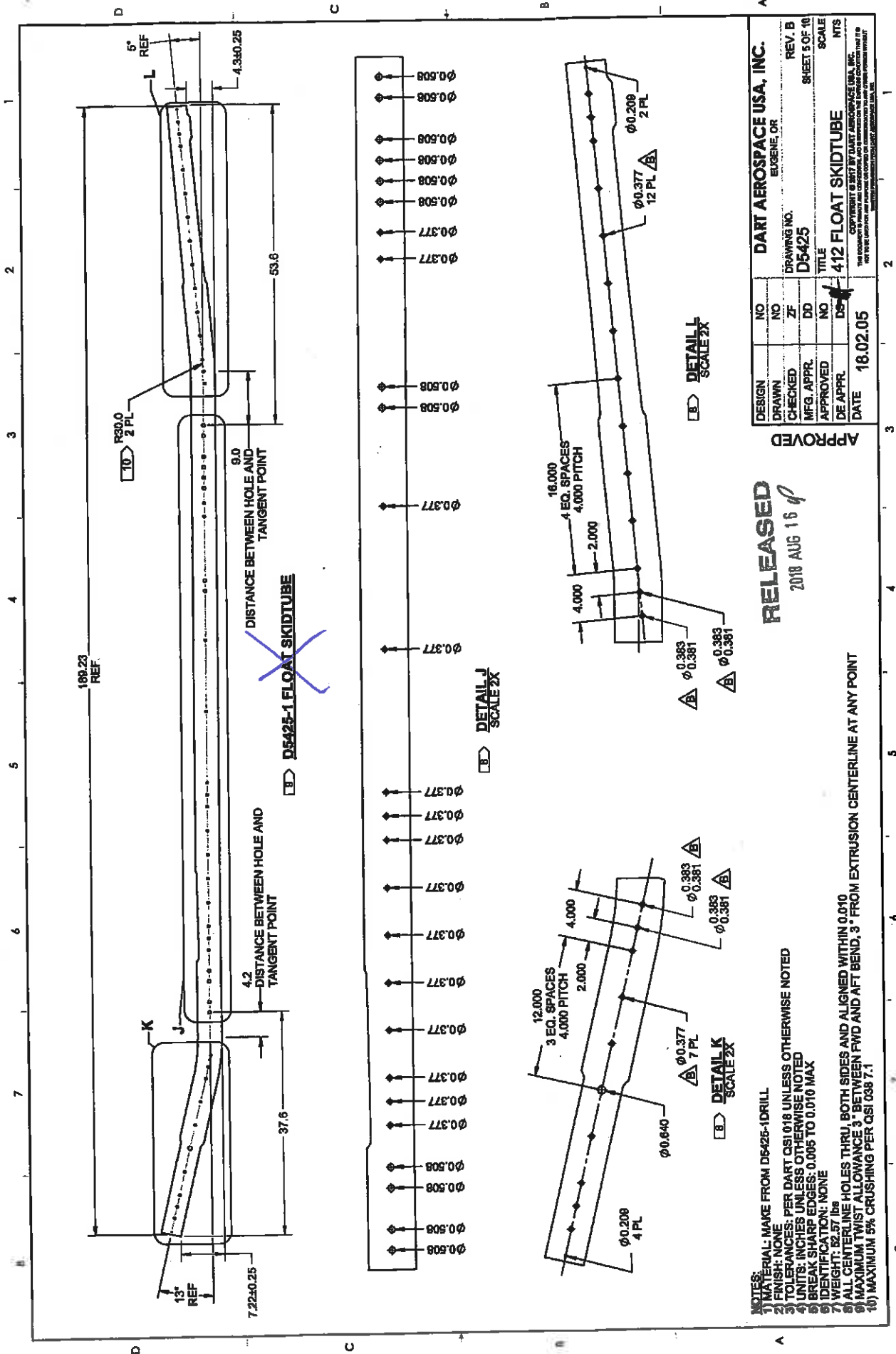


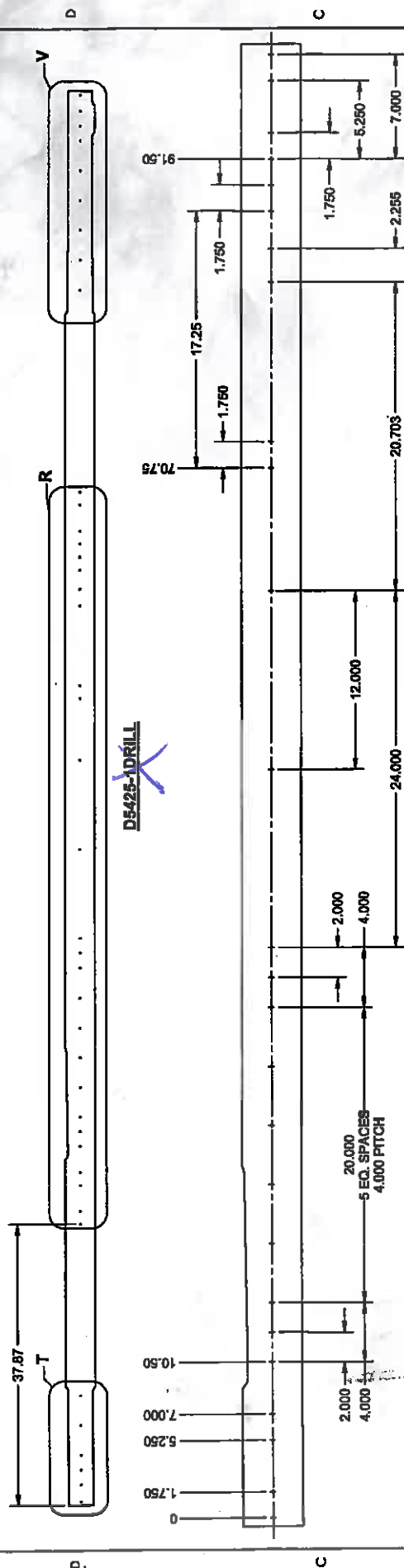
D5425-043 FLOAT SKIDTUBE ASSY

RELEASED
2018 AUG 16

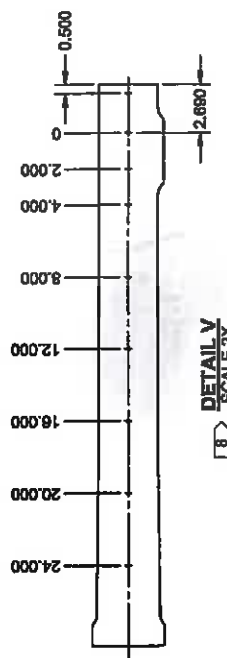
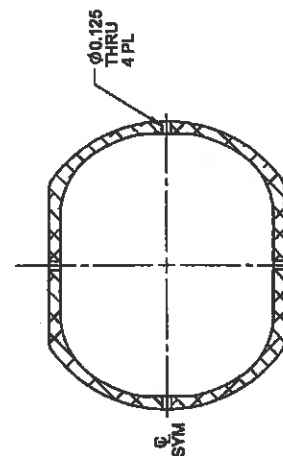
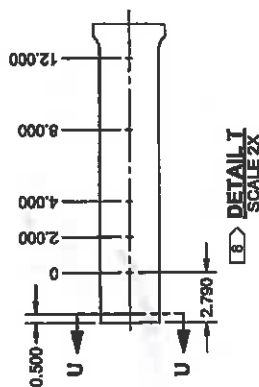
DESIGN		NO	DART AEROSPACE USA, INC.	
DRAWN	CHECKED	NO	EUGENE, OR	
MFG. APPR.	APPROVED	2F	DRAWING NO. D5425	
DE APPR.	DATE	DD	REV. B SHEET 3 OF 10	
		NO	TITLE 412 FLOAT SKIDTUBE	
		D5	SCALE NTS	
		18.02.05		

PROPERTY OF DART AEROSPACE USA, INC.
THIS DOCUMENT IS LOANED TO YOU BY DART AEROSPACE USA, INC.
IT IS TO BE USED FOR THE PURPOSES OF THE PROJECT FOR WHICH IT WAS LOANED.
IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.





D5425-1 DRILL



DESIGN	NO	DART AEROSPACE USA, INC.
DRAWN	NO	EUGENE, OR
CHECKED	ZF	DRAWING NO.
MFG. APPR.	DD	D5425
APPROVED	DD	TITLE
DATE	DD	412 FLOAT SKIDTUBE
DATE	18.02.05	NTS

REV. B
SHEET 7 OF 10
SCALE
NTS

Copyright © 2005 by DART AEROSPACE USA, INC.
This document is property of DART AEROSPACE USA, INC. and is loaned to the customer for their use only. It is not to be distributed outside the customer's organization without the written permission of DART AEROSPACE USA, INC.

DATE

2018 AUG 16 10

SECTION U-U
SCALE 4X

NOTES:
 (1) MATERIAL: MAKE FROM D5425-MACH
 (2) FINISH: NONE
 (3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 (4) UNITS: INCHES UNLESS OTHERWISE NOTED
 (5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 (6) IDENTIFICATION: NONE
 (7) WEIGHT: 52.67 lbs
 (8) ALL CENTERLINE HOLES $\phi 0.125$ THRU. BOTH SIDES AND ALIGN
 MAINTAIN 0.005 TOLERANCE TO ALL SYMMETRY AND CENTER L



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)			
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					

DART AEROSPACE LTD		Work Order: 198593
Description: Float skittube assembly		Part Number: DS425-043
Inspection Dwg: DS425-3 Rev: 13		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/- .010	.510	✓		Vernier	
2.790	+/- .010	2.782	✓		Vernier	
10.790	+/- .010	10.799	✓		Vernier	
14.790	+/- .010	14.800	✓		Vernier Tape	
43.120	+/- .010	43.130	✓			
44.870	+/- .010	44.880	✓			
48.37	+/- .010	48.380	✓			
60.37	+/- .010	60.380	✓			
64.37	+/- .010	64.380	✓			
74.37	+/- .010	74.380	✓			
123.328	+/- .010	123.336	✓			
125.87	+/- .010	125.880	✓			
129.37	+/- .010	129.380	✓			
131.12	+/- .010	131.130	✓			
134.62	+/- .010	134.630	✓			
136.37	+/- .010	136.380	✓		Tape	
0.500	+/- .010	.510	✓		Vernier	
2.690	+/- .010	2.700	✓		Vernier	
4.69	+/- .010	4.700	✓		Vernier	
18.69	+/- .010	18.700	✓		Tape	
15.24	+/- .030	15.250	✓		Tape	
R1.0	+/- .100	R1.0	✓		Gabrit	
0.350	+0.000 / - .020	0.339	✓		palpeur dans machine	
0.350	+0.000 / - .020	0.344	✓		palpeur dans machine	
R1.0	+/- .100	R1.0	✓		Gabrit	
1371	+/- .030	13.725	✓		Tape	
0.152	+/- .015	.146	✓		palpeur dans machine	
0.250	+/- .015	.240	✓		palpeur dans machine	
9.35	+/- .030	9.375	✓		Tape	
0.350	+0.000 / - .020	0.339	✓		palpeur dans machine	
20.00	+/- .030	20.000	✓		Tape	
0.250	+/- .015	.246	✓		palpeur dans machine	

Measured by: M.M.	Checked by: DAS 68	QC Inspector:
Date: 2019/10/26	Date: 9-89	Date:

Engineering Approval: (if necessary)	Date:
---	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

faite dans le coté et pas # 3/100 M.M

